

# Work Order ID 64950

Tuesday, January 04, 2011 3:05:55 PM



Page 1

Item ID: D350-636-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*RL*

Date: 1/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4168

A

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-015 CHG 001

*Sulak24*

*OK for a 11/01/21*

364950

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
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QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168.

6- Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.

9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D4168. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) and .210" (total of 1 hole per side)

1 0 8E 11/6/16

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M115778

12-Grind welds flush as per Dwg D4168

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

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Stop

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Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 884/01/10

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DD 11-1-10

W/O:		WORK ORDER CHANGES					
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Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D4168.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

Open wearplate holes to size as per dwg (4 holes per sides)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291 batch: M116040 ☐ ☐  
exp. date: 09/2011

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1  
& QSI004

(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod batch: M116577

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 11/01/11

BE 11/01/11  
BE 11/01/11

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Start Date: 1/4/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D4168

12- C'bore section CG-CG

13- Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 115951

Memo

0.00

Powder Coating

START TIME: 10:10  
OVEN TEMPERATURE: 320°  
FINISH TIME: 10:40

1 BR 11-01-20.

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

=> M 11/01/20

1 BR 11-01-20.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop

Sequence ID/  
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Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00



HandFinish

HandFinishing

Hand Finishing

Memo

1- Install inserts as per Dwg D4168

0.00

230

0.00



HandFinish

HandFinishing

Hand Finishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N17

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

SIKA FLEX 241

BATCH: M115114EXP DATE: 11/01

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M1141895-Coat all exposed fasteners with "LPS Procyon" batch: 114256

W/O:		WORK ORDER CHANGES					
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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(a)			
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00				(H)			
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

W/O:		WORK ORDER CHANGES					
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270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-636-015

Location: 72PPP rev: A

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/1/24 SD R

CK 11/01/24

ME

11-01-24

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# Picklist Print

Tuesday, January 04, 2011 3:06:03 PM

Page 1

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH




Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																					
AN3C34A  BOLT		Purchased	No			230	Each	80.0000	1	1																								
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST353</td><td>80</td><td></td></tr><tr><td>115767</td><td>10</td><td>X1</td></tr><tr><td>116003</td><td>20</td><td></td></tr><tr><td>116075</td><td>50</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST353	80		115767	10	X1	116003	20		116075	50							
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ST353	80																																	
115767	10	X1																																
116003	20																																	
116075	50																																	
AN3C36A  BOLT		Purchased	No			230	Each	141.0000	4	4																								
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>ST353</td><td>141</td><td></td></tr><tr><td>109771</td><td>6</td><td></td></tr><tr><td>116050</td><td>50</td><td></td></tr><tr><td>116239</td><td>10</td><td></td></tr><tr><td>116381</td><td>70</td><td>X4</td></tr><tr><td>116522</td><td>5</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	ST353	141		109771	6		116050	50		116239	10		116381	70	X4	116522	5	
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114801	1																																	
115908	24	/																																
ST354	40																																	
116381	20																																	
116523	20																																	

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C42A Purchased No 230 Each 97.0000 1 1  
BOLT

D3873-1 Manufactured No 230 Each 273.0000 7 7  
Bushing

Location Loc Qty Loc Code  
ST354 97  
106176 97  
ST089 100  
64567 100  
ST092 170  
62197 40  
63314 30  
64760 100  
ST093 3  
57615 3

D4154-041 Manufactured No 230 Each 0.0000 1 1  
Wearplate Assembly

D4170-1 Manufactured No 230 Each 27.0000 4 4  
Bushing

Location Loc Qty Loc Code  
LG 27  
62251 4  
62669 1  
63322 22

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, January 04, 2011 3:06:03 PM

Page 3

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230 Each

11.0000

1

1



Bushing



11/01/20

## Location

## Loc Qty

## Loc Code

ST135

11

62710

11

x1

MS21043-3

Purchased No

230 Each

1,731.000

5

5



11/01/20

Nut

## Location

## Loc Qty

## Loc Code

FG

76

103691

76

ST301

1655

112314

1655

x5

NAS1149C0363R

Purchased No

230 Each

5,568.000

9

9



11/01/20

Washer

## Location

## Loc Qty

## Loc Code

ST297

5568

113524

46

113644

22

113889

500

114742

5000

x9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 04, 2011 3:06:03 PM

Page 4

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased No

230 Each

340.0000 4 4



WASHER



11/10/120

## Location

## Loc Qty

## Loc Code

FG 40  
102472 40  
ST277 300  
111819 66  
113362 234

AN960JD816

Purchased No

250 Each

105.0000 2 2



1/2" washer, Alum



11/12/18

## Location

## Loc Qty

## Loc Code

ST348 105  
106043 105

D2744

Manufactured No

110 Each

32.0000 1 1



Cap



BE 11/01/05

## Location

## Loc Qty

## Loc Code

ST 32  
62715 32

D2600-3-BENT

Manufactured No

110 Each

14.0000 1 1



Extrusion Bent



BE 11/01/06

## Location

## Loc Qty

## Loc Code

LG 14  
61634 4  
62764 1  
64434 9

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 04, 2011 3:06:03 PM

Page 5

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

170.0000

8

8



Crossbolt Spacer



BE 1/10/11

Location

Loc Qty

Loc Code

LG

170

50281

10

57953

2

59111

10

61844

64

64003

84

3

D2739

Manufactured No

160

Each

13.0000

1

1



350 I Beam



BE 1/10/11

Location

Loc Qty

Loc Code

LG

13

62688

3

64448

10

1

D3490-3

Manufactured No

160

Each

59.0000

4

4



Cross Bolt Spacer



BE 1/10/11

Location

Loc Qty

Loc Code

LG

59

60294

1

62668

6

63556

30

64006

22

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6  
10

Work Order ID: 64950



Parent Item: D350-636-015



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160 Each 89.0000 4 4



Cross Bolt Spacer



*BEH/p1/7*

Location Loc Qty Loc Code

LG 89

59424 3

62450 56

64005 30

ALS4-1032-225 Purchased No

230 Each 4,124.000 4 4



Insert



*HL 11/01/20*

Location Loc Qty Loc Code

PK011 4124

110768 4124

D3492-041 Manufactured No

230 Each 97.0000 8 8



Plug Assembly



*HL 11/01/20*

Location Loc Qty Loc Code

FP013 97

59114 1

62210 3

63994 93

AN8C35A Purchased No

230 Each 44.0000 1 1



BOLT



*HL 11/01/20*

Location Loc Qty Loc Code

ST346 44

114442 5

115188 13

115960 26

*XL*

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 7

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230 Each

21.0000

1

1



Blade Fitting Assembly, LH



11/01/20 PTO =>

Location

Loc Qty

Loc Code

FG008

10

62002

10

FP007

2

56052

2

FP18

9

61689

9

X1

AN6C44A

Purchased No

230 Each

79.0000

4

4



BOLT



11/01/20

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

77

111649

2

114653

1

114941

24

115936

50

X4

MS21083C8

Purchased No

230 Each

67.0000

1

1



NUT



11/01/20

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

X1

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Shop Packet Print

Page 7

# Picklist Print

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Page 8

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230

Each

201.0000

8

8



Washer



11/01/20

## Location

## Loc Qty

## Loc Code

ST072

201

60755

9

63647

192

8

AN960C10L ~~NAS1149C0332~~ Purchased No

230

Each

25.0000

4

4



washer

M116025



x4 11/08/20

## Location

## Loc Qty

## Loc Code

ST245

25

107534

25

D2745 Manufactured No

230

Each

185.0000

8

8



Bushing



11/08/20

## Location

## Loc Qty

## Loc Code

ST023

185

52311

5

59112

4

61988

68

63315

108

x8

AN960C816L ~~NAS1149C0832R~~ Purchased No

230

Each

0.0000

1

1



WASHER

M114915



# Picklist Print

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Page 9

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

65.0000

8

8



Plug Assembly



11/01/20 PTO

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

63

59117

1

59190

4

63996

58

V8

AN3C6A

Purchased

No

230

Each

241.0000

4

4



BOLT



11/01/20

Location

Loc Qty

Loc Code

ST351

241

111982

166

116419

75

X4

MS21043-6

Purchased

No

230

Each

578.0000

4

4



NUT



11/01/20

Location

Loc Qty

Loc Code

ST301

578

112314

578

X4

D3493-1

Manufactured

No

250

Each

16.0000

2

2



Washer



11/1/218

Location

Loc Qty

Loc Code

ST062

16

61672

16

2

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Shop Packet Print

Page 9

# Picklist Print

Tuesday, January 04, 2011 3:06:03 PM

Page 10

Work Order ID: 64950

Parent Item: D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

67.0000



NUT



11/1/21 SP

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

2

AN8C21A

Purchased

No

250

Each

87.0000



BOLT



2 11/1/21 SP

Location

Loc Qty

Loc Code

ST345

87

113558

1

114653

2

115723

24

116381

60

2

D2741

Manufactured

No

250

Each

47.0000



Blade, 350 Skidtube



1 11/1/21 SP

Location

Loc Qty

Loc Code

ST466

47

60210

12

61341

35

1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/01/20	230	Plug Assembly Assembly with D2594-3 / M61762 041 "0" rings	JK	11/01/20	x8		S 11/01/20	
11/01/20	230	Plug Assembly Assemble with NAS1611-013 / M1116582 043 "0" rings	JK	11/01/20	x8		S 11/01/20	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149C0363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149C0332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149C0832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

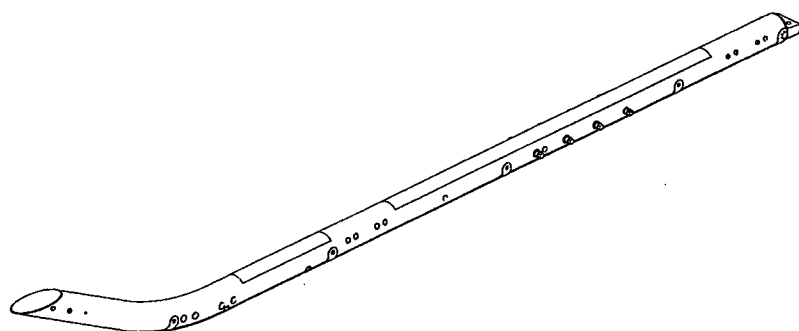
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 04950

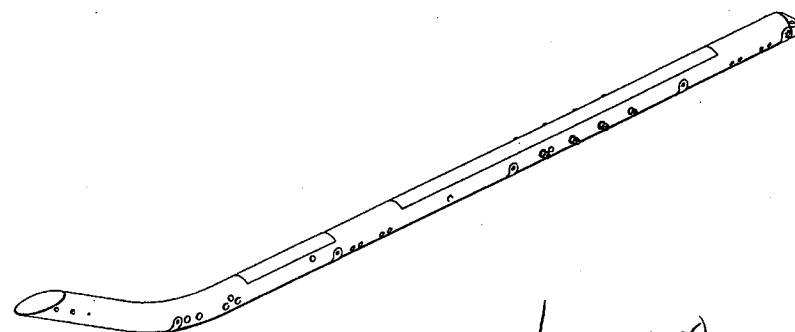
PS 11-01-4

RELEASED  
2010-09-15

A NEW ISSUE		SC	10.08.09
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D4168-041 350 SKIDTUBE ASSEMBLY, LH**

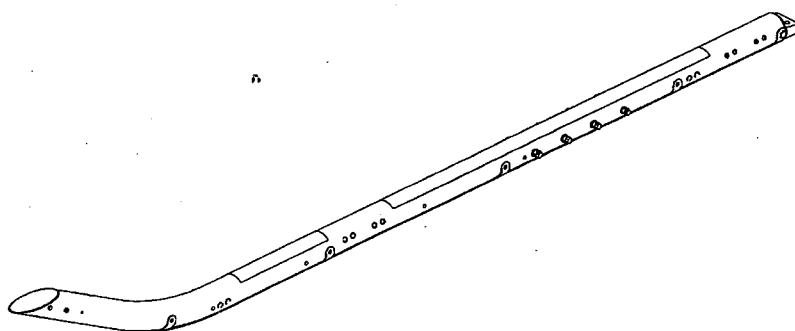


**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

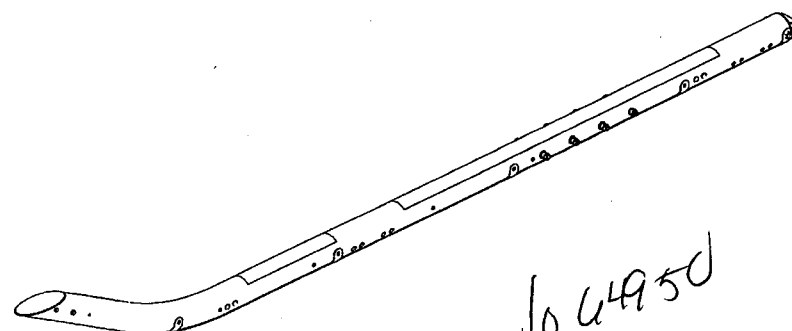
*W064950*

**RELEASED**  
2010-09-15  
JMT

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D4168-043 350 SKIDTUBE ASSEMBLY, LH**



**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

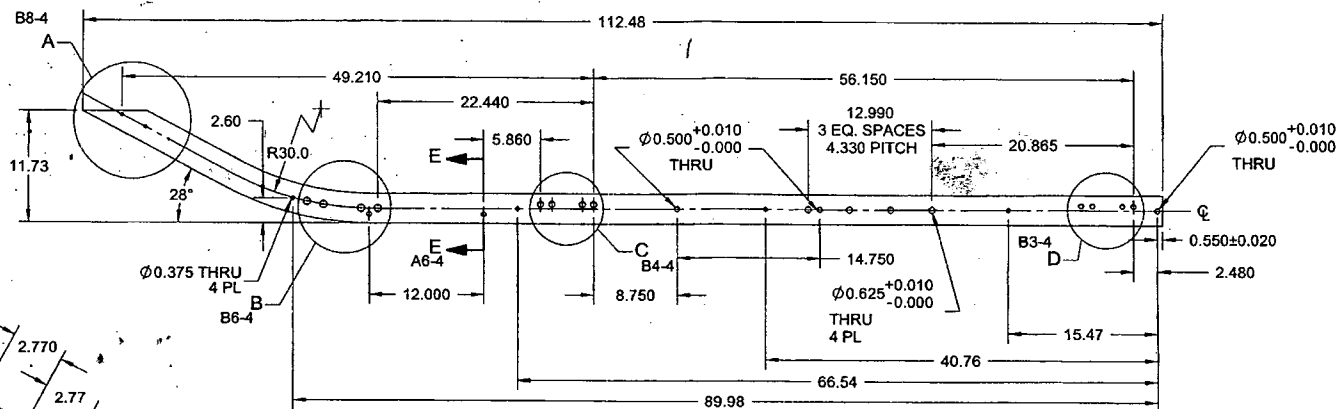
**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, VA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

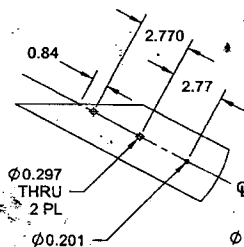




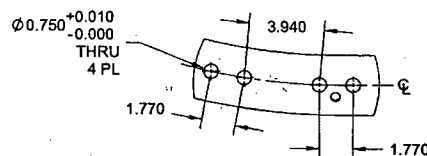
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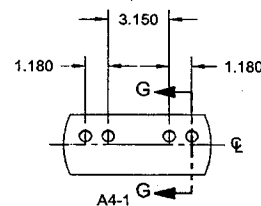
**D4168-1 LH SKIDTUBE**



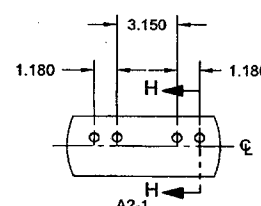
**DETAIL A**  
SCALE 2X



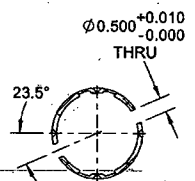
**DETAIL B**  
SCALE 2X



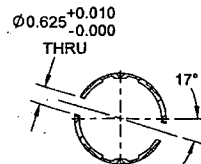
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SCALE 2X



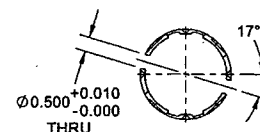
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



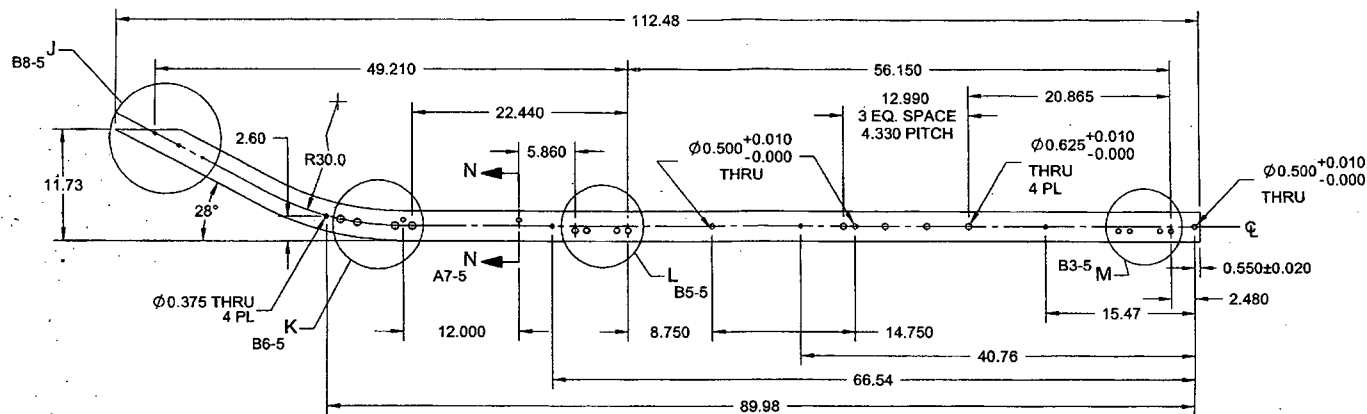
**SECTION H-H**  
SCALE 3X, 4 PL

*w/o 44950*

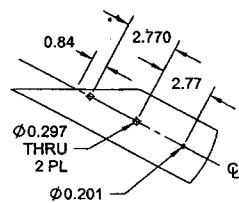
**RELEASED**  
2010-09-15

SCALE 3X, 4X		<b>DART AEROSPACE USA, INC.</b>	
DESIGN	SC	PORT HADLOCK, WA	
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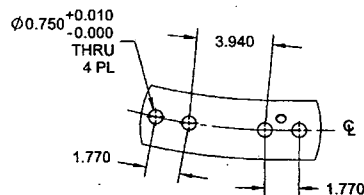
8 7 6 5 4 3 2 1



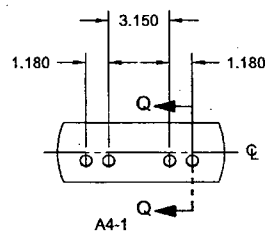
**D4168-2 RH SKIDTUBE**



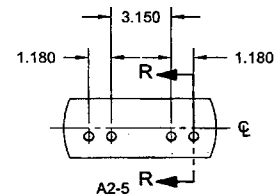
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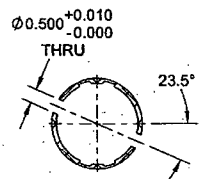
**DETAIL K**  
SCALE 2X



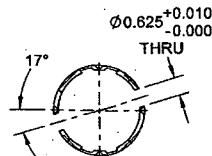
**DETAIL L**  
SCALE 2X



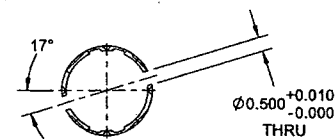
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

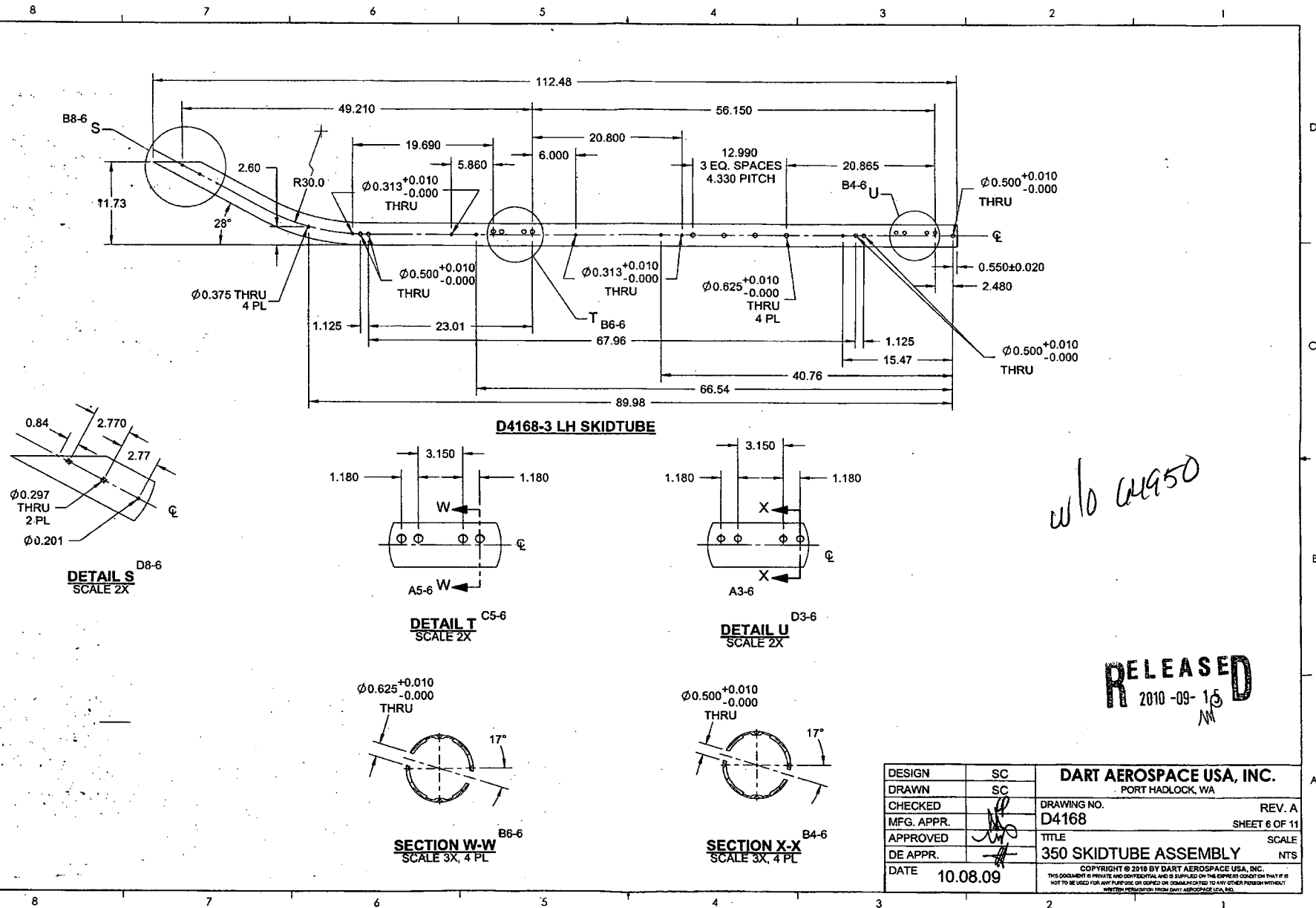


**SECTION R-R**  
SCALE 3X, 4 PL

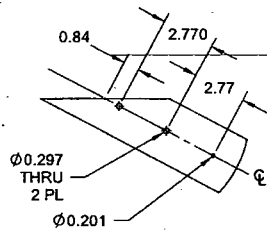
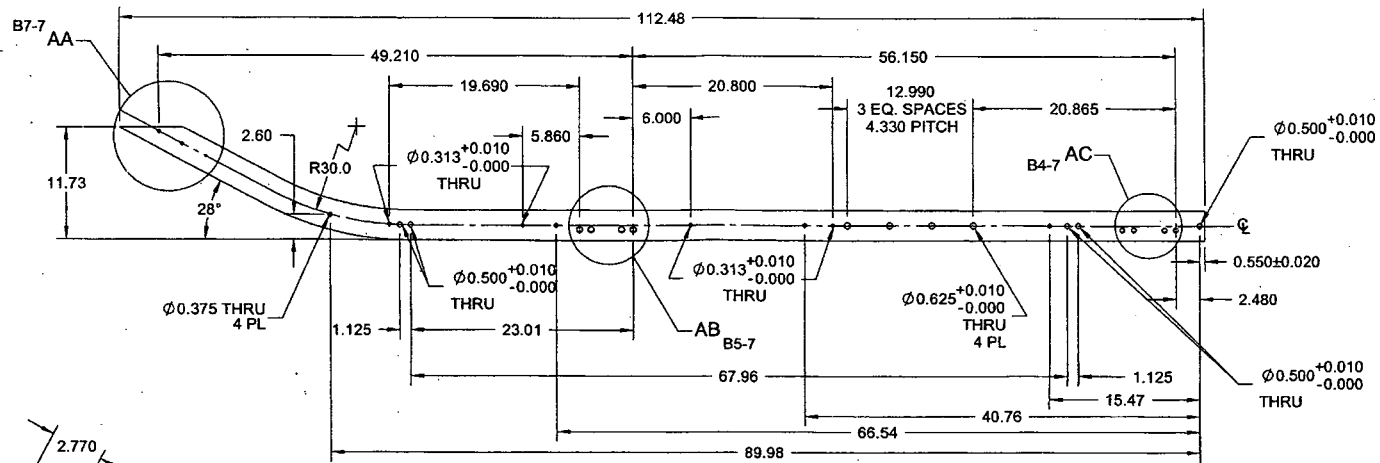
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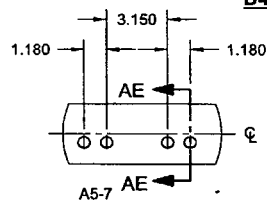
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2010-09-15  
*MD*



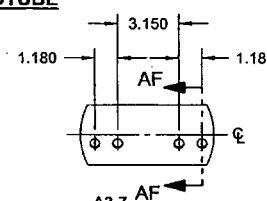
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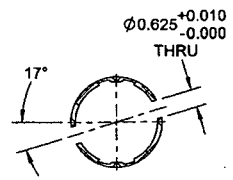
**DETAIL AA**  
SCALE 2X  
D7-7



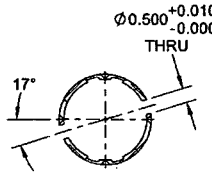
**DETAIL AB**  
SCALE 2X  
C4-7



**DETAIL AC**  
SCALE 2X  
D3-7



**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7



**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

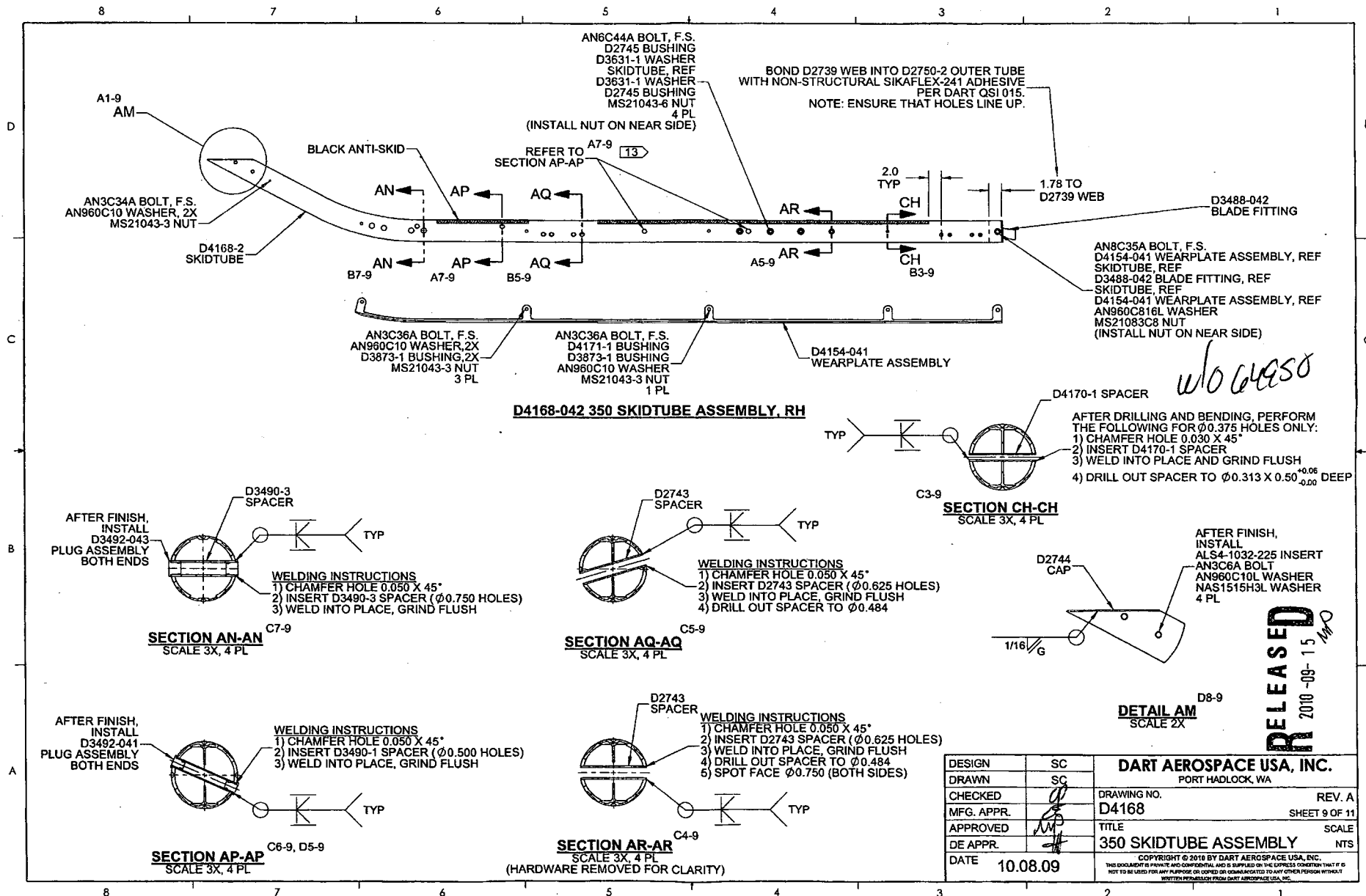
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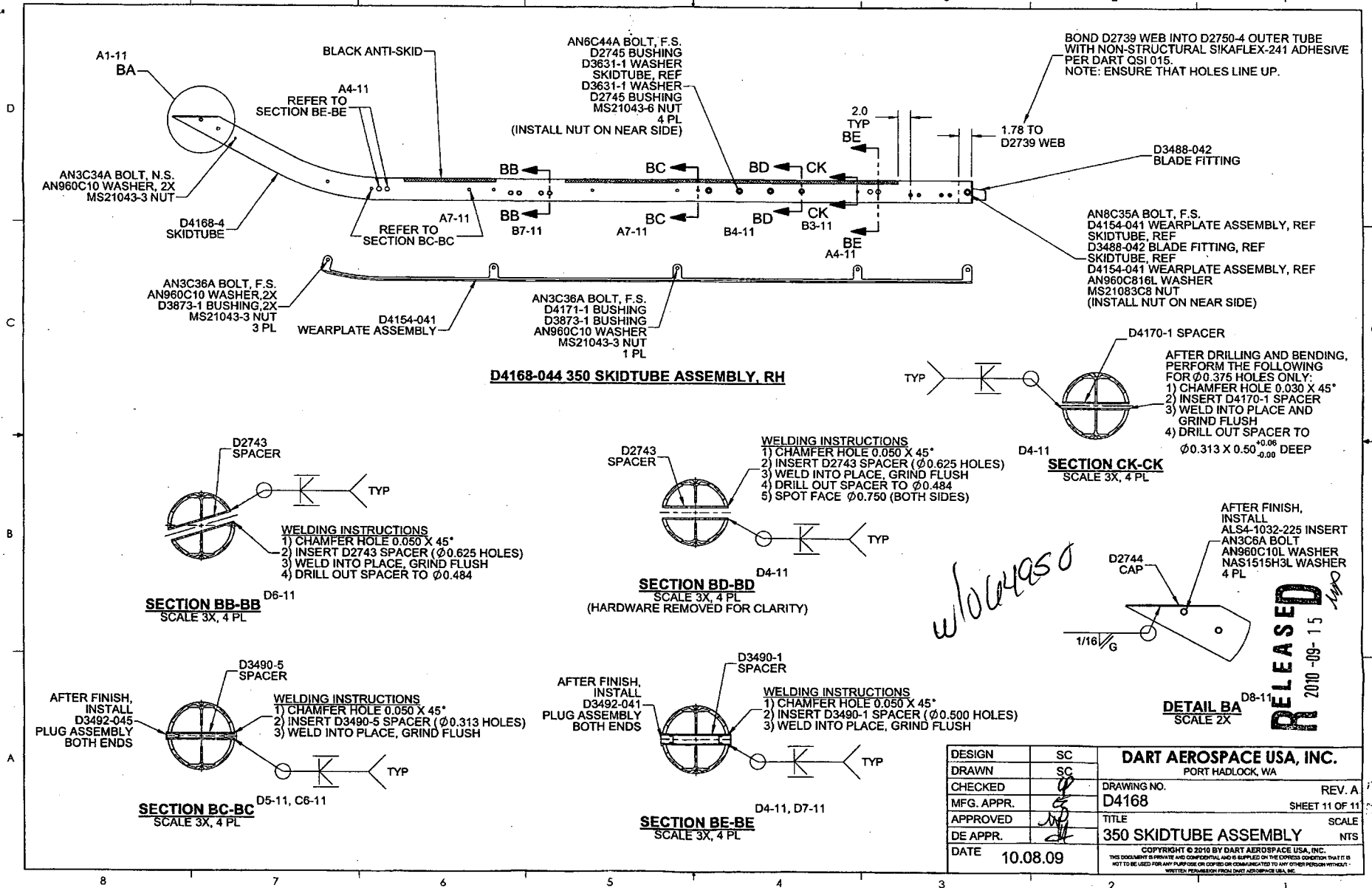








8 7 6 5 4 3 2 1



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NO. 243

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barkley Elliott  
Job number: ~~64950~~ 64953  
Part number: J 350-636-016  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Salvatore Date of Test Coupon 11-01-18

Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld